



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2933-1

Job Sheet 180984



Part No: D2933-1

Job Qty: 4 ea

Part Name: Saddle LH In, 206



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/19/18

Job Tracking No:

Due Date: 8/3/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP: B 00.06.26 New DWG rev (mpp 2069) EC IPP Rev:C As per Rev C 07-03-19 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		8/3/18	0.00	0.00	Start Up Machining-1		SBL 18/08/05
100	CNC Vertical Machining	4 pcs		8/3/18	0.40	5.92	HAAS1-2		SBL 18/08/05
110	Mill Conv	4 pcs		8/3/18	0.00	0.25	Mill Conv 1		SBL 18/08/05
120	QC	4 pcs		8/3/18	0.00	0.00	QC1		SBL 18/08/05
130	QC	4 pcs		8/3/18	0.00	0.00	QC8 Machining-1		21mm 18/08/09
140	HandFinish	4 pcs		8/3/18	0.00	0.19	HandFinish1		M 18-08-13
150	Powdercoat	4 pcs		8/3/18	0.00	0.14	Powdercoat1		18-08-13
160	QC	4 pcs		8/3/18	0.00	0.00	QC3		AUG 17 2018
170	Packaging	4 pcs		8/3/18	0.00	0.00	Packaging3-1		21 AUG 2 2018
180	QC21-SA	4 Ea		8/3/18	0.00	0.00	QC21		21 AUG 2 2018

Part Op 100 - Program part number and batch number. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & Descriptions: attached Dimension Sheet

110 - Machine Keyway and inspect per attached dimension sheet

120 - Inspect on CMM as per folio CMMA020.

150 - START TIME: 8:00am 3264F 8:30am

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-001	Saddle Billet	4 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6101-001	4	77	0

Part Specifications

Specifications could not be found.

Plex 7/19/18 7:11 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR _____ Date : _____	DISPOSITION Rework ☐ Scrap ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machine ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
		MRB (QSI042) Approval _____ Disposition _____
		Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____

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CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S098926

Part: D2933-1

Job No: 180984

Serial No/Batch: S098926

Revision: _____

Inspector: _____

Exp Date: _____

Instructions: Various STC's

Date: 06/03/16

Environment

Design	Operator
Doc/Data	Offset/Setup
Equip/Tooling	Supplier
Handling/Pre	Training
Material	Use for Testing
Internal Transport	Poor Information
Tribal Knowledge	Rushing
LOA	Product Improvement
Substation	Process Improvement
Past Expiry Date	Manufacturing Process
Misidentified	Past Due

Bending

Centre Not Concentric

Cracks

Crimp/Kink/Ripple/Wave

Cuffs

Crushing

Heat Treat

Wave/Twist in Tube

Marks/Chatter

Set-up

BOM/Route

Broken/Damage/Defect

Inspection Incomplete/Unqualified

Contamination

Countersink

Cut Too Short

Instructions Incomplete/Unclear

Drill Holes

CATEGORY ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center	☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence
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OTHER : _____

DART AEROSPACE LTD		Work Order: 180984
Description: 206 Saddle, Inboard, Left side		Part Number: D2933-1
Inspection Dwg: D2933 Rev: C DSK: Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		0.196	0.194	.125	.125	
B	0.100	0.140		0.126	0.174	.122	.123	
C	0.100	0.140		0.118	.110	.110	.110	
D	0.210	0.230		0.230	0.222	.222	.222	
E	1.245	1.255	/	1.258	1.25	1.25	1.25	
F	1.245	1.255	/	1.250	1.25	1.25	1.25	
G	2.495	2.505	/	2.500	2.500	2.500	2.500	
H	0.510	0.515		0.577	.510	.510	.510	
I	1.572	1.582	/	0.511	1.577	1.577	1.577	
J	2.495	2.505	/	2.50	2.50	2.50	2.50	
K	0.257	0.262	/	0.257	.257	.257	.257	
L	0.312	0.317	/	0.312	0.312	0.312	0.312	
M	0.235	0.240		0.237	0.239	.239	.239	
N	0.100	0.140		0.128	.130	.130	.130	
O	0.540	0.560		0.549	.550	.550	.549	
P	0.490	0.510		0.499	.500	.498	.499	
Q	3.715	3.725	/	3.72	3.72	3.72	3.72	
R	2.470	2.510	/	2.50	2.50	2.50	2.50	
S	0.240	0.270		0.256	.245	.248	.250	
T	0.100	0.180	/	0.125	.138	.138	.130	
U	1.625	1.635	/	1.63	1.63	1.63	1.63	
V	1.362	1.372	/	1.367	1.367	1.367	1.367	
W	0.316	0.321	/	0.316	0.316	0.316	0.316	
X	1.125	1.145	/	1.125	1.125	1.125	1.125	
Y	1.565	1.585	/	1.565	1.565	1.565	1.565	
Z	0.178	0.198	/	0.188	0.188	0.188	0.188	
AA								
AB								
AC								
AD								
AE								

DAS Accept/Reject

Measured by: 57 9-89 18/08/05	Date:
Audited by: [Signature]	Date: 18/08/09
Prototype Approval: N/A	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	06.10.03	Removed DT8683, DT8686 & DT8690	KJ/JLM	
D	07.03.21	Revised per drawing revision C	KJ/JLM	
E	08.01.16	DT8695 A/B removed from dimension Y	KJ/EC/DD	[Signature]

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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